

Work Order ID 134783

134783

Page 1

Monday, July 20, 2015 2:42:55 PM

Item ID: D2622-120C Accept *N900040100* Setup Start *NS1*
 Revision ID: *101* Stop *NS2*
 Item Name: Step Extrusion
 Start Date: 7/20/2015 Start Qty: 110.00 *110* Cust Item ID:
 Required Date: 7/20/2015 Req'd Qty: 110.00 *110* Customer:
 Reference:

Approvals: Process Plan: *MLS* Date: JUL 20 2015 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2622	Rev C1								

100 PURCHASING 0.00
 100
 Purchasing
 Purchasing
 Memo 0.00
 Issue P/O: *29236* a) Extrude as per Dwg D2622 Rev. Cb)
 Material: 6061-T6 (QQ-A-200/8)c) Minimum yield tensile strength = 35
 ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation =
 8%f) Order at 120" longg) Bon L Canada Inc.

4 150722

110 Receive & Inspect for Damage & Mat'l Certs 0.00
 110
 Packaging
 Packaging
 Memo 0.00
 Ensure material certification is attached

121 *DAS*
06
9-89
 SEP 02 2015

120 QC18 In-Coming Inspection Material 0.00
 120
 QC
 Quality Control
 Memo 0.00
 Check Pull test per Dwg D2622 for compliance page attached Check hardness
 with Webster tester

121 *1509-08*
 DAS
 9
 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube</td><td style="width: 15%;">Cross tube</td><td style="width: 15%;">Water Jet</td><td style="width: 15%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>						Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
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								Completed By																	
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								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐														
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐														
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐														
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐														
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐														
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐														
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :																					
Misidentified	☐	Past Due	☐																						

Work Order ID 134783***134783***

Page 2

Item ID: D2622-120C

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Extrusion

Start Date: 7/20/2015 Start Qty: 110.00

110

Cust Item ID:

Required Date: 7/20/2015 Req'd Qty: 110.00

110

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

*Back
Held*

0.00

130

Packaging

Memo

0.00

Packaging

LOCATION WA003

(121) [Signature] 15-10-1

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ **OCT 05 2015***MLJ* **OCT 05 2015**

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																								

Picklist Print

Monday, July 20, 2015 2:42:59 PM

Page 1

Work Order ID: 134783

134783

Parent Item: D2622-120C

D2622-120C

Parent Item Name: Step Extrusion

Start Date: 7/20/2015

Required Date: 7/20/2015

Start Qty: 110.00

Required Qty: 110.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120CP		Purchased	No			110	Each	0.0000	1	110			
D2622-120CP									**	121			
Extrusion													

DAS
06
9-09

SEP 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

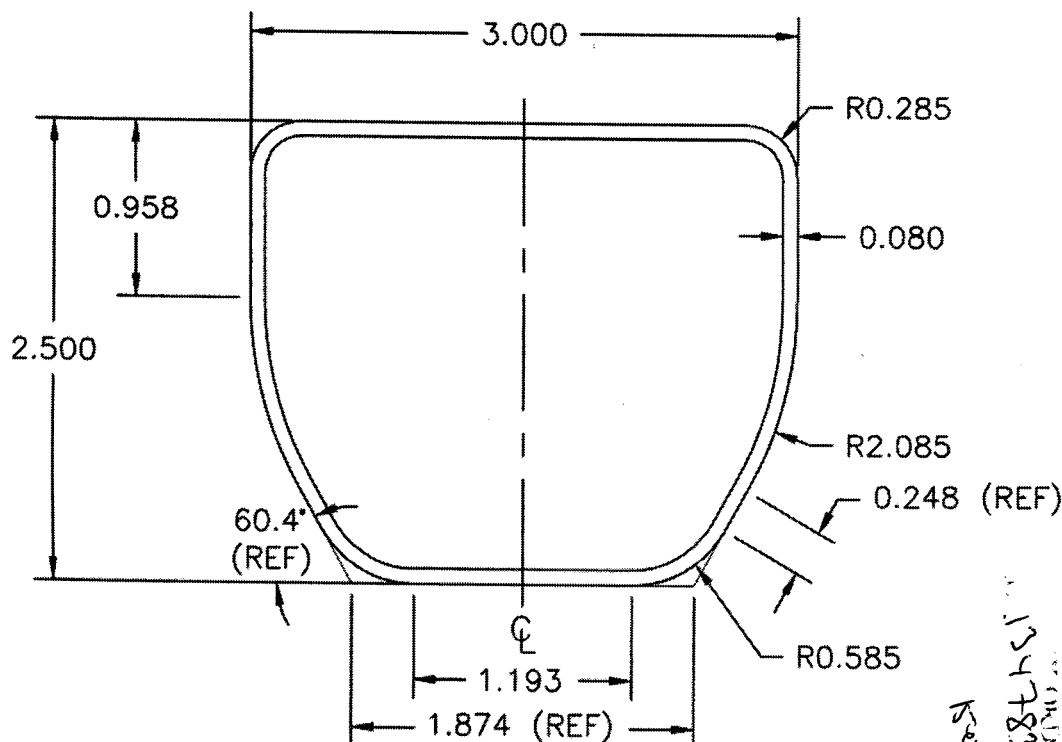
Work Order update only ☐

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DESIGN	KE	DRAWN BY	4P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE	02.09.11			TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29			NEW ISSUE	
B	97.12.12			CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11			0.080 WAS 0.085; ADD PART & DIE No.	
C1	02.10.04			ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 #



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A $\triangle$ C1
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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